



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBH9928-2
Job Sheet 187448



Part No: RBH9928-2

Job Qty: 10 ea

Part Name: Trim Tab Bender



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBH9928-2 Rev K IPP Rev A 17.11.13 New Issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K DP Verify DD IPP Rev.C 18.01.18 Updated process, all done under assy. JFS Verified by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/19	0.00	0.00	Start Up Machining-4		P.J. 18-12-09
100	Bandsaw	10 pcs		1/25/19	0.00	0.25	Bandsaw1		P.J. 18-12-09
110	Mori Seiki	10 pcs		1/25/19	0.00	5.00	NV5000-1		P.J. 18-12-09
120	QC	10 pcs		1/25/19	0.00	0.00	QC2 Machining-5		P.J. 18-12-09
130	QC	10 pcs		1/25/19	0.00	0.00	QC8-7		18-12-16
140	Brake NC	10 pcs		1/25/19	0.00	5.00	Brake NC 1		
155	QC	10 pcs		1/25/19	0.00	0.00	QC5		
165	Outsource	10 pcs		1/25/19			ATG001-VC GROUP 8		18-12-17
175	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging2		DEC 19 2018
180	QC	10 pcs		1/25/19	0.00	0.00	QC6		38
190	Small Fab	10 pcs		1/25/19	0.00	5.00	Small Fab		ML 9-88 DAS
200	QC	10 pcs		1/25/19	0.00	0.00	QC5		DAS 38
210	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging3		28 9-88
220	QC21-SA	10 Ea		1/25/19	0.00	0.00	QC21		DAS 21 9-89 JAN 14 2019

Part Op 100 - Cut blanks to 8.00"

Descriptions: 110 - 1-Machine RBH9928-2-1 & RBH9928-2-3 as per folio FB676 FOLIO REV: AA DWG REV:

2-Deburr NOTE: ***Machine both parts at same time***

130 - Engrave T/N number ONLY (RBH9928-2) using Marktronic engraver as per DWG.

140 - Form RBH9928-2-1 as per DWG. -Remove bending marks -Broach RBH9928-2-3 as per DWG. -Tumble to remove buffer marks

165 - Issue P/O to ATG : PO 042057 ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

190 - Assemble as per DWG. Sheet 1

FORM
ASSEMBLY
ALD22E
JFS ACCEPTABLE

MA JAN 9/19 *PUSH*

5042201 = 1 PCS
5090358 = 10 PCS

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250X6.250	6061-T651 Sheet 0.250" Thick Plate x 6.250" Wide	6.6600 ft (.666 ea)	90-Start up Operation	
92356A247	Carriage Bolt	20 Ea (2 ea)	190-Small Fab	5082860
96659A104	Washer	20 Ea (2 ea)	190-Small Fab	5011316
KKT-11A	Knurled Knob	20 Ea (2 ea)	190-Small Fab	5044356

Job Allocations

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier ☐</td> </tr> <tr> <td></td> <td></td> <td></td> <td>Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐				Quality ☐																												
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Date :	Sequence #:	QTY Affected :		MRB (QSI042)																																													
Description Work Order Deviation			Disposition																																														
			Completed By																																														
			Lead hand / Supervisor																																														
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Other/Details:																																																	

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.250X6.250	7	9	0
190-Small Fab	92356A247	20	83	0
	96659A104	20	31	0
	KKT-11A	20	23	0
Part Specifications				
Specifications could not be found.				

Plex 12/4/18 1:31 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S135863



Part: RBH9928-2

Job No: 187448

Serial No/Batch: S135863

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 12/09/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	187408
Description: clamp and TAB Bender		Part Number:	RBH9928-2-1 et-2
Inspection Dwg:	Rev: K	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	Clamp					
.25	H/- .010	.249	✓		mc06	
.016	H/- .005	.016	✓		mc06	
.500	H/- .005	.500	✓		mc06	
.063 rad	H/- .005	.06	✓			
1.250	H/- .005	1.250	✓		mc06	
2.205/.208	—	.194			pin	
2.200/.203	—	.190			mc06	
.0625	H/- .005	.624	✓		mc08	
6.00	H/- .010	6.00	✓		mc06	
4.0000	H/- .002	3.999	✓		mc06	
1.000	H/- .002	.999	✓		mc08	
	TAB Bender.					
6.00	H/- .010	5.999	✓		mc06	
.75	H/- .010	.747	✓		mc06	
27°	H/- .5°	27.2°	✓		Block	
R.062	H/- .005	.06	✓			
.63	H/- .010	.625	✓		mc06	
1.0000	H/- .002	.999	✓		mc08	
4.000	H/- .002	4.001	✓		mc08	
Ø.194	-.001 to .004	.193	✓		pin	
.313	H/- .005	.311	✓		mc06	
.69	H/- .010	.685	✓		mc06	
1.38	H/- .010	1.375	✓		mc06	

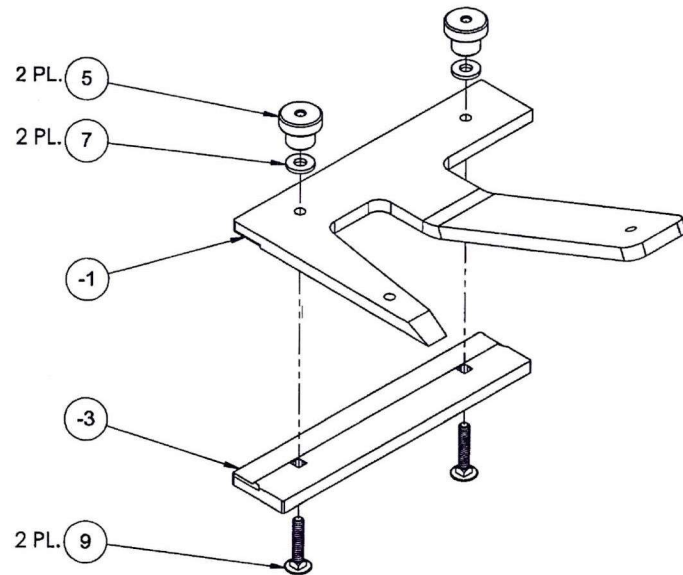
Measured by: P.J. / S.C.L.	Checked by: [Signature]	QC Inspector:
Date: 18-12-09	Date: 18/12/17	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

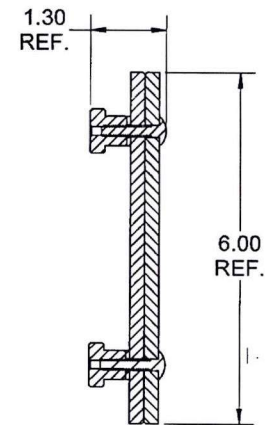
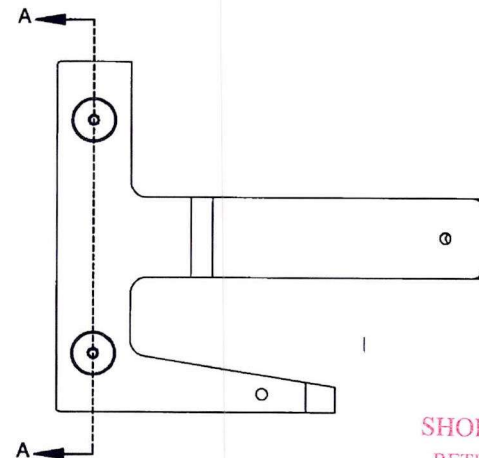
ITEM #	QTY	PART #	TITLE	PG
-1	1	RBH9928-2-1	TAB BENDER	2
-3	1	RBH9928-2-3	CLAMP	3
5	2	ESSENTA #KKT-11A	FEMALE KNOB KNURLLED	-
7	2	McMaster#96659A104	# 10 STAINLESS STEEL SAE FLAT WASHER	-
9	2	McMaster#92356A247	SQUARE NECK CARRIAGE BOLT #10-24 X 1" LG.	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
9	SEPERATED FROM RBH9928	-	6/5/13	BIM	EB
10	-1 CHD DISTANCE OF RADIUS FROM .500 (X2) TO .670 (X2). -3 CHD DISTANCE OF RADIUS FROM .625 (X2) TO .670 (X2). CHD NON-CRITICAL DIMENSION PRECISION FROM .XXX TO .XX.	-	7/31/13	RJC	GE
K	TEMPLATE UPDATED AS PER HAWKESBURY STANDARDS. -3 DRILL AND BROACH DIMENSION CHANGED. -1 & -3 RADIUS ALONG THE EDGE DIMENSIONS ADDED, TOLERANCE ADDED ON -1 & -3	17-669	17.09.22	VM	WM



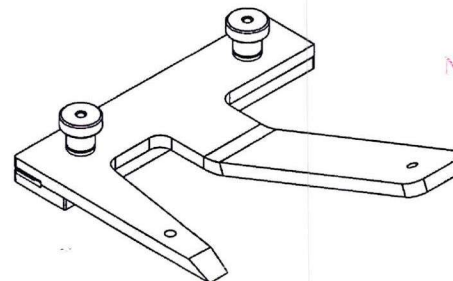
RBH9928-2 TAB BENDER

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) HEAT TREAT: N/A/N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) USED IN ASSEMBLY RBH9982



SECTION A-A

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 187448 MJS
 18/12/04



DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE TAB BENDER			
DWG NO. RBH9928-2			
DESIGN BY:	VM 9/22/2017	XXX ± .005 FRACTIONS ± 1/8	REV K
DRAWN BY:	WM 11/15/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	WM 11/15/2017	X ± .1 SURFACES = 125	
MFG. APPR:	DP 11/16/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 11/16/2017	2. INTERPRET DIM AND TOL. PER ASME Y14.5M-2009	
DATE:	11/15/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
SHEET 1 OF 3			
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042057**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042057
PO Date: 12/17/18
Due Date: 12/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

revised

*-cls qty. signed
PO behind.*

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187448	RBH9928-2	Trim Tab Bender -Issue P/O : PO ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	10 pcs	0 pcs	10 pcs	\$9.25/pcs	\$92.50
2	184749	RB DB3188L-5	Drain Hose Adapter -Issue P/O : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	7 pcs	0 pcs	7 pcs	\$1.25/pcs	\$8.75
3	186433	RBW7839-2G-1	Quill -Issue P/O : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	8 pcs	0 pcs	8 pcs	\$1.25/pcs	\$10.00



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042057**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	185789	RB DB3188L-1	Drain Hose Adapter -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	9 pcs	0 pcs	9 pcs	\$1.25/pcs	\$11.25
						DEC 19 2018					
5	185158	RB T101740	Tail Rotor Blade Rigging Tool -Issue P/O to GROUPE ALTECH: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/21/18	5 pcs	0 pcs	5 pcs	\$16.25/pcs	\$81.25
						DEC 19 2018					
Grand Total:											\$203.75

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/19/18 9:56 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015441-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015441 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Dec-2018		Aman		042057				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir/ Back Order
1	RBH9928-2 Rev.	RBH9928-2 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
2	RDBB3188L-5 Rev.	RDBB3188L-5 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	7	7	0	0	0
3	RBW7839-2G-1 Rev.	RBW7839-2G-1 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	8	8	0	0	0
4	RDBB3188L-1 Rev.	RDBB3188L-1 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	9	9	0	0	0
5	RBT101740 Rev.	RBT101740 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.